

Date: Thursday, 13/11/2008 8:20:42 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 43406
 Estimate Number : 12740
 P.O. Number :
 This Issue : 13/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D353523
 Drawing Number : D3535 REV B
 Project Number : N/A
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : B
 Material :
 Previous Run : 39134 Due Date : 28/11/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-02-15 JLM
 Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Of Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 1.4296 sf(s)/Unit Total : 14.2958 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 109088 B8-11-18

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

B8-11-18

B

2-Deburr if necessary B8-11-18

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B8-11-18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/11/18 (13)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D3535 using Jig DT8158
 3-Identify as D3535-23

S 08/11/24 (13)
 08/11/24 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 8:20:42 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43406

Part Number: D353523

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sosul24 (x13)

7.0

POWDER COATING

POWDER COATING



M109648



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
320°F
12:00

M-1 08/11/24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

OE-11-24

(x13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(13X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-21

M-1 08/11/24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

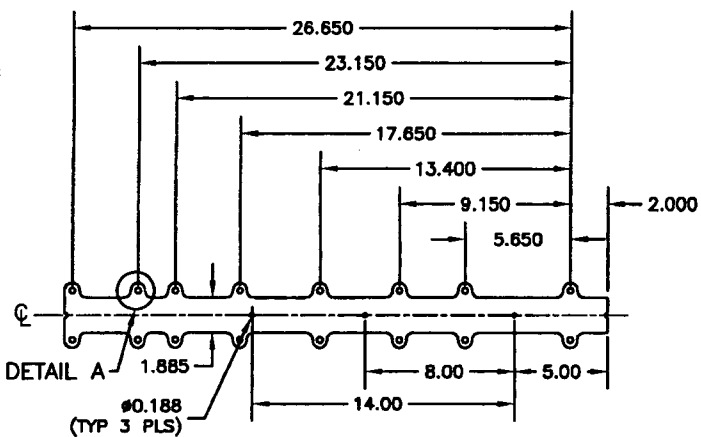
NOTE: Date & initial all entries

DART

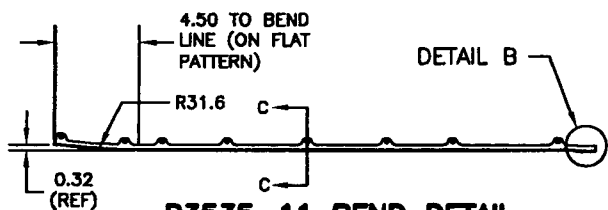
RELEASED

07.04.24

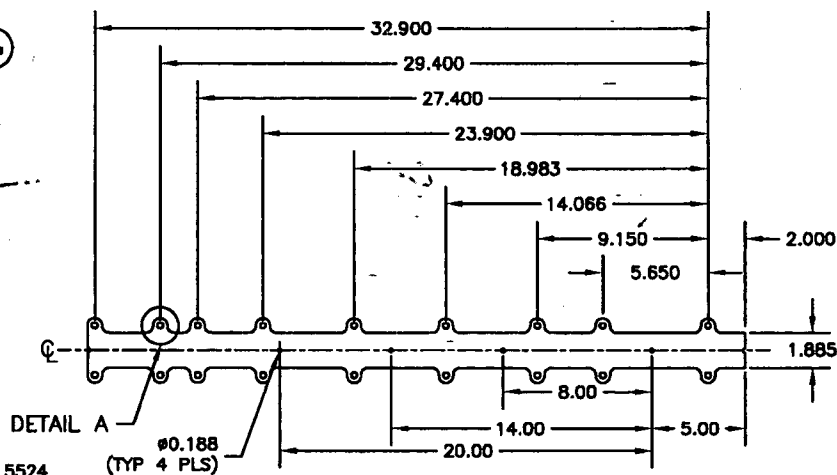
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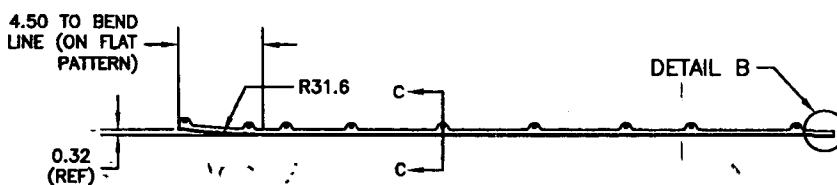
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

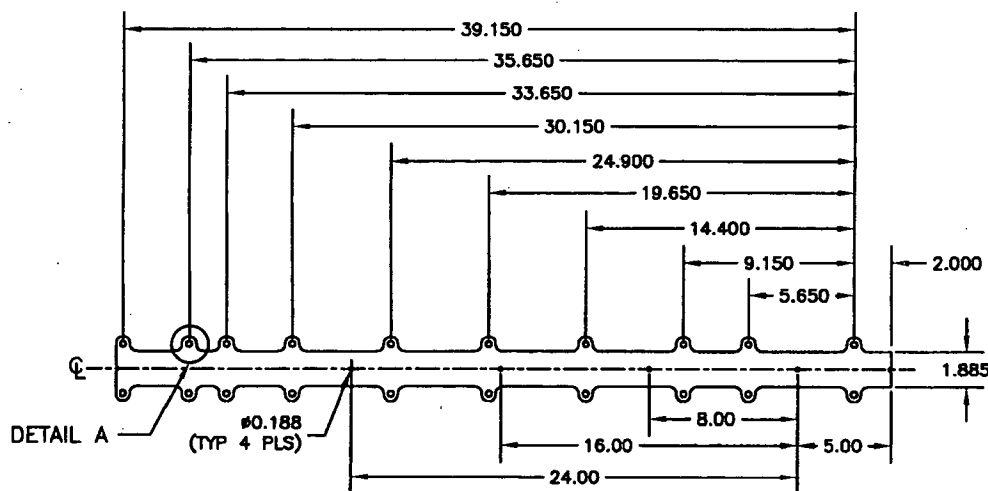
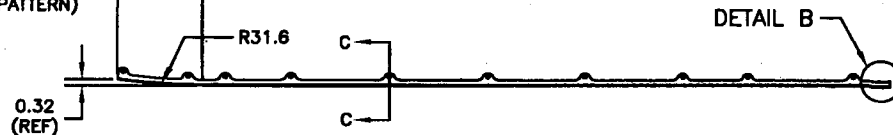
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
TH	TH	D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

DART

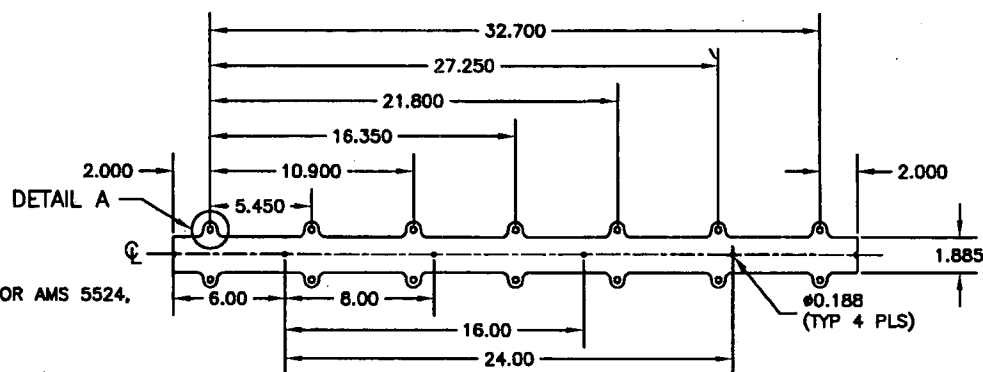
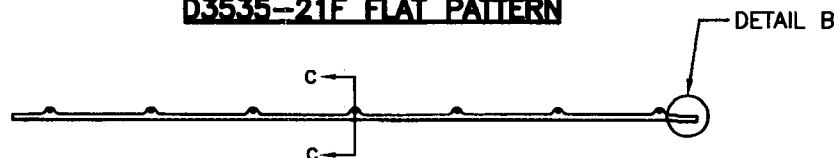
RELEASED

07.04.24

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 2 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15 BEND DETAIL**

W043406

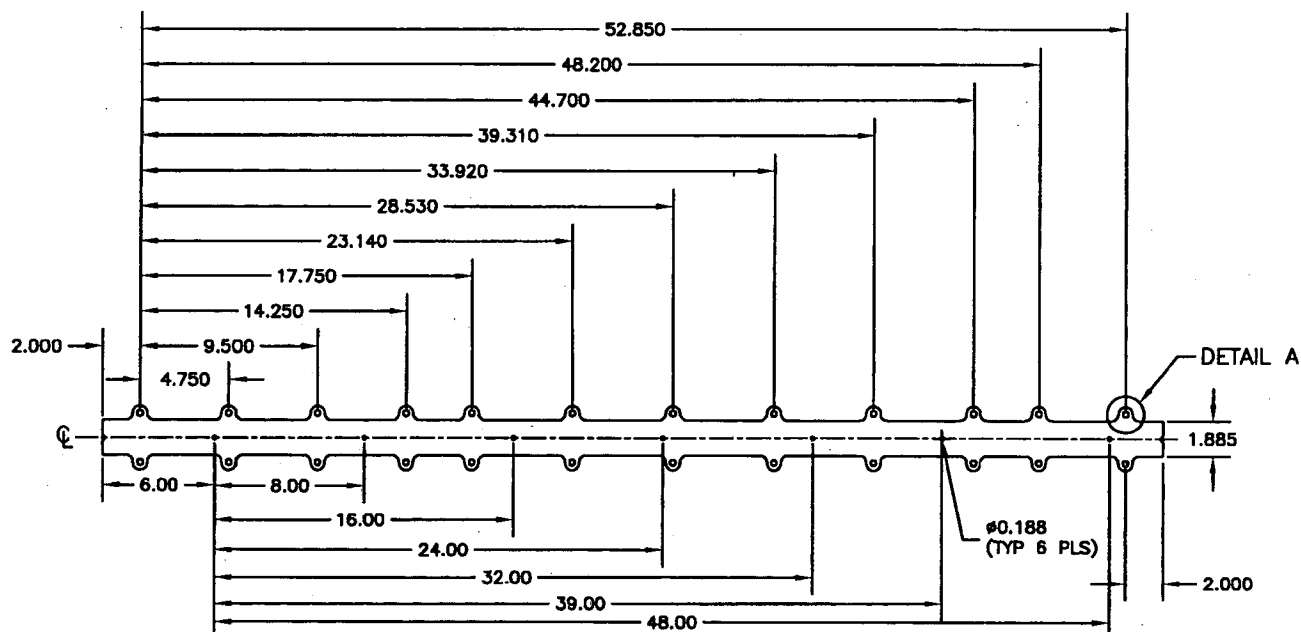
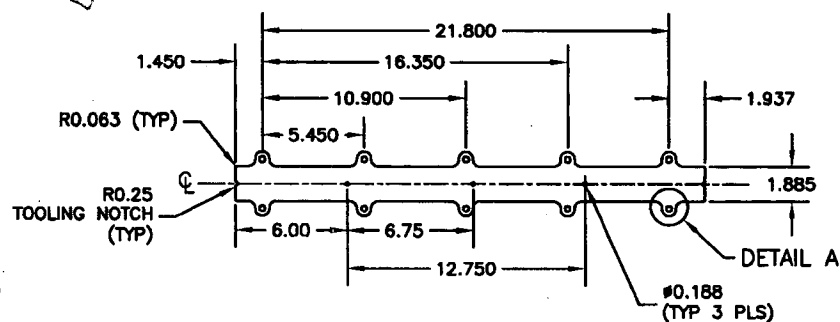
**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

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07.04.24

**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
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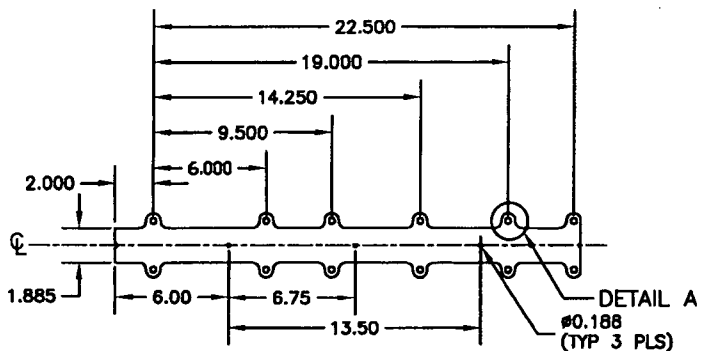
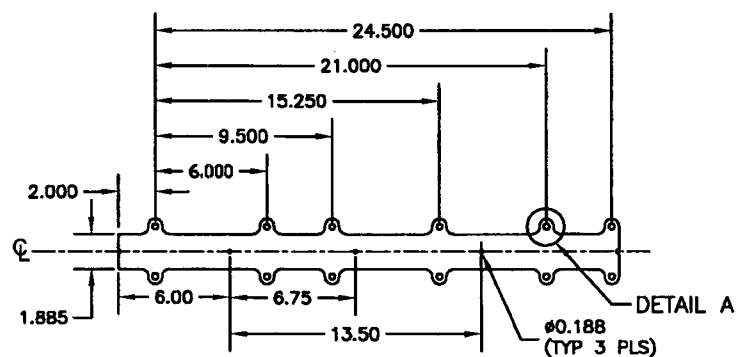
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CHECKED	#	APPROVED	#	PORT HADLOCK, WA	
DATE	07.04.17	TITLE	D3535	WEARSHOE	SHEET 3 OF 7
					SCALE 1:10

Mo 43406

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07.04.24

**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

W043406

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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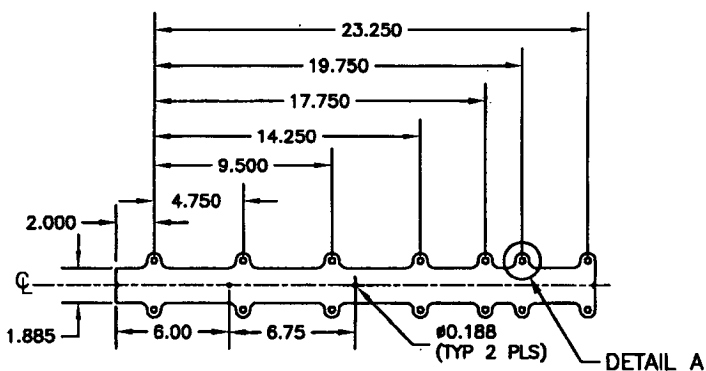
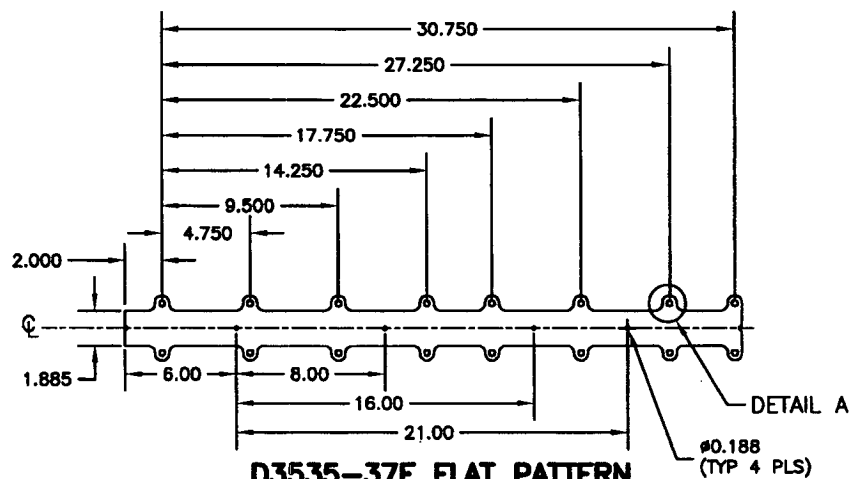
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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
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DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	

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07.04.17

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 5 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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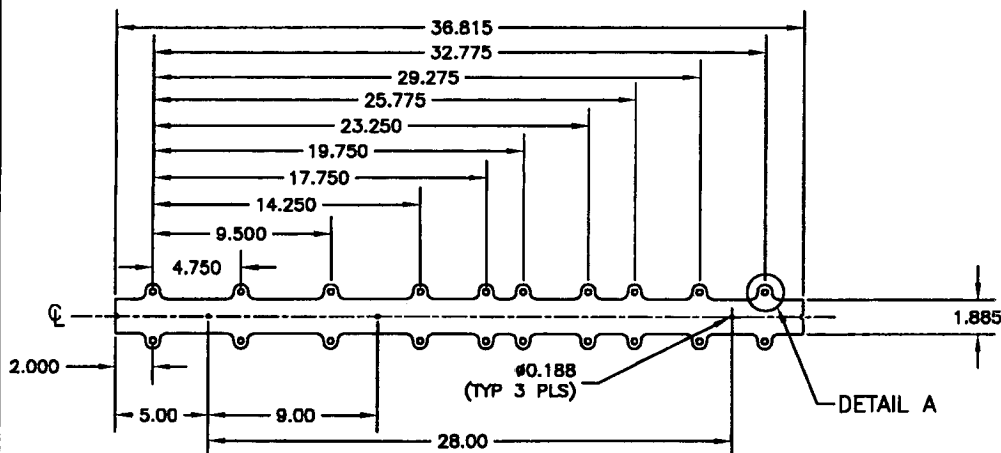
No 43406

DART

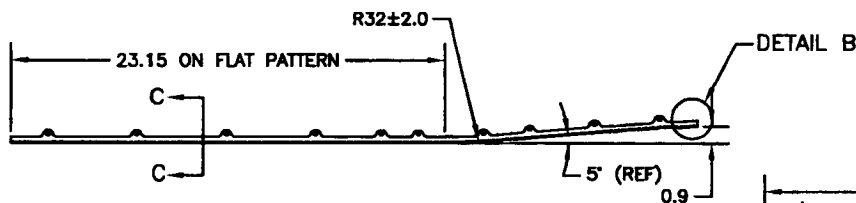
RELEASED

07.04.24

DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REVISION
			WEARSHOE	SHEET 6 OF 7
				SCALE
				1:10

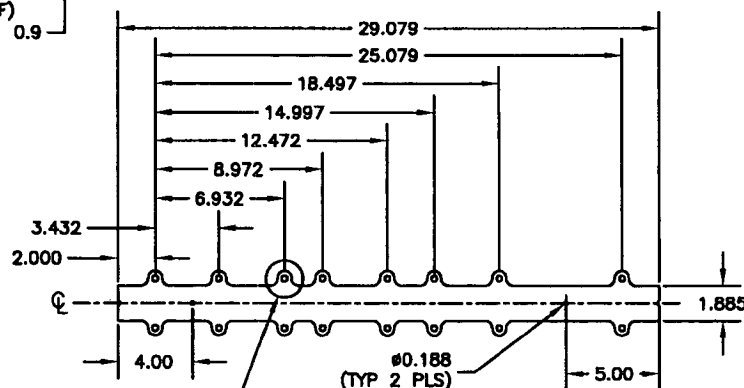


D3535-39F FLAT PATTERN

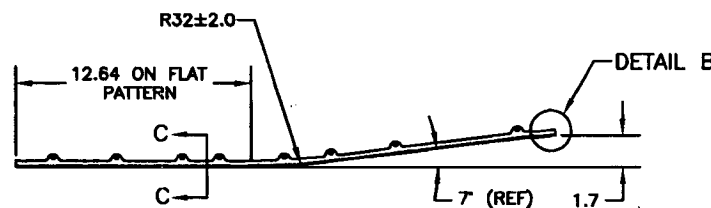


D3535-39 BEND DETAIL

W043406



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

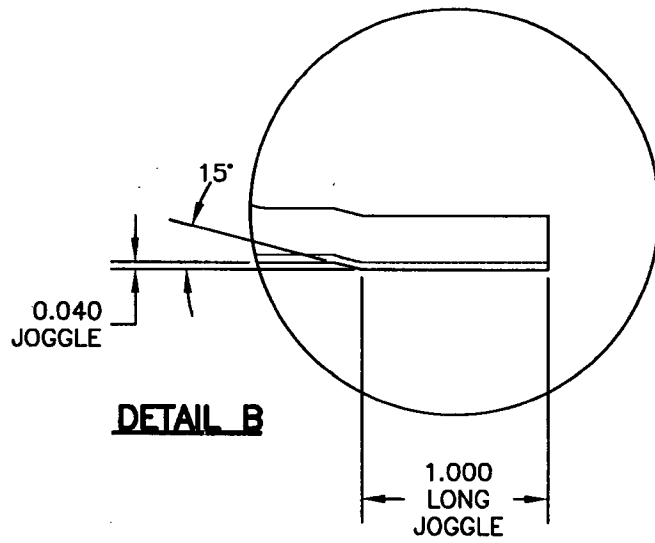
NOTES

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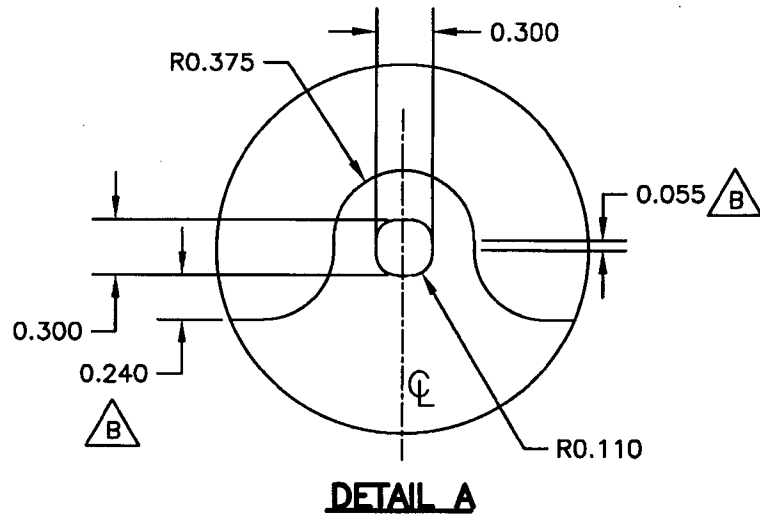


DESIGN	C8	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. B
CHECKED		APPROVED		PORT HADLOCK, WA	SHEET 7 OF 7
DATE	07.04.17	TITLE	WEARSHOE	SCALE	1:1

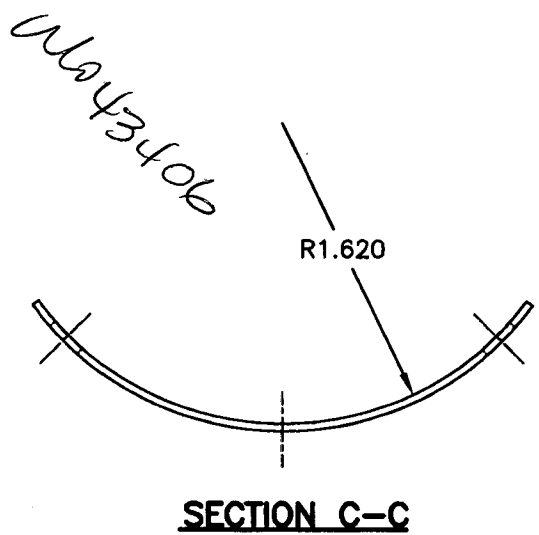
RELEASED
07.04.24



DETAIL B



DETAIL A



SECTION C-C

DART AÉROSPACE LTD		Work Order: 43406
Description: WEAR SHOE		Part Number: D3535-23
Inspection Dwg: D3535-23 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.190	X			
.300 X .300	+/- .010	.302 X .303	X			
1.885	+/- .010	1.888	X			
2.000	+/- .010	2.000	X			
2.000	+/- .010	2.000	X			
6.00	+/- .030	6.00	X			
8.00	+/- .030	9.00	X			
16.00	+/- .030	16.00	X			
24.00	+/- .030	24.00	X			
32.00	+/- .030	32.00	X			
39.00	+/- .030	39.00	X			
48.00	+/- .030	48.00	X			
4.750	+/- .010	4.751	X			
9.500	+/- .010	9.503	X			
14.250	+/- .010	14.250	X			
17.750	+/- .010	17.750	X			
23.140	+/- .010	23.140	X			
28.530	+/- .010	28.530	X			
33.920	+/- .010	33.920	X			
39.310	+/- .010	39.310	X			
44.700	+/- .010	44.700	X			
48.200	+/- .010	48.200	X			
52.850	+/- .010	52.850	X			

Measured by: PB	Audited by: S
Date: 8-11-18	Date: 08/11/18

Prototype Approval: A
Date: A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]